Monday, 5/7/2007 9:12:56 AM Jean-Luc Menard **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : DOUBLER Job Number : 31865 **Estimate Number** : 12825 : D3578041 : NA P.O. Number Part Number S.O. No. : HA This Issue : 5/7/2007 **Drawing Number**  D3578 REVA : NC : N/A Prsht Rev. Project Number : 4/17/2007 SMALL /MED FAB First Issue **Drawing Revision** Previous Run : PIA Material 60 Um: : 5/12/2007 Each **Due Date** Qty: Written By **Checked & Approved By** Comment : Est: A 07.04.11 New issue EC **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** 1.0 M6061T6S080 6061-T6 .080 Sheet Comment: Qty.: 0.4410 sf(s) 0.0074 sf(s)/Unit Total: 6061-T6 sheet 0.080" (M6061T6S080) ottacher. Batch: FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3578 (Run prog. D3578-1) Dwg Rev:\_\_ Prog Rev:\_\_\_\_ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 x60 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Open rivet holes to 0.098" and C'sink as per dwg D3578

Monday, 5/7/2007 9:12:57 AM Jean-Luc Menard **Process Sheet** omer: CU-DAR001 Dart Helicopters Services **Drawing Name: DOUBLER** Job Number: 31865 Part Number: D3578041 Job Number: Seq. #: Machine Or Operation: Description: 6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVE Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 MS21075L3 Nutplate Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s) **Nutolate** Batch: 11 1853 07/05/16 MS20426AD33 9.0 Rivet Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s) Rivet 10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 2-Assemble as per dwg D3578 11.0 QC5 INSPECT WORK TO CURRENT STEP

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Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:\_\_\_\_

U 07.05.66



Date:

Monday, 5/7/2007 9:12:57 AM

User:

Jean-Luc Menard

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: DOUBLER** 

Job Number: 31865

Part Number: D3578041

Job Number:

Seq. #:

**Machine Or Operation:** 

Description:

13.0

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dono5/16

Job Number Prsht Rev. Previous Run Written By Checked & Approved By

Tuesday, 4/17/2007 11:13:38 AM

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

: 31865

Estimate Number

: 12825

P.O. Number

: 4/17/2007 This Issue

: 11 First Issue

: NC

S.O. No. :

Type

: SMALL /MED FAB

**Drawing Number** 

Project Number **Drawing Revision** 

**Drawing Name** 

Part Number

Material

**Due Date** 

: 5/12/2007

: DOUBLER

: D3578041

: N/A

: A

: D3578 REVA

Qty:

60 Um:

Each

Comment

Additional Product

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M6061T6S080

6061-T6 .080 Sheet

Comment: Qtv.:

0.0074 sf(s)/Unit Total:

0.4410 sf(s)

6061-T6 sheet 0.080" (M6061T6S080)

Batch: MIOUIST

FLOW WATER JET

9AD 07/04/05 (60

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3578 (Run prog. D3578-1)

Dwg Rev: \_\_A 

SAD 07/05/04



2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

MS21075L3

Nutplate



1.0000 Each(s)/Unit

Total:

60.0000 Each(s)



Comment: Qty.:

Batch:

Nutplate



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Stosts	to	Split who	St	<del>57/05/16</del>						
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Part No	\ <u> </u>	PAR #: Fault Category: NO	CP: Vo	s No DQ	<u> </u>	Date:				

					QA: N/	Closed:	Date: _				
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC Corrective Action Section B				Vorification		T			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:13:38 AM Ùser: Kim Johnston **Process Sheet** Drawing Name: DOUBLER Customer: CU-DARO01 Dart Helicopters Services Job Number: 31865 Part Number: D3578041 Job Number: Description: Seq. #: Machine Or Operation: Rivet 6.0 MS20426AD33 Comment: Qty.: Total: 120.0000 Each(s) 2.0000 Each(s)/Unit Rivet SMALL & MEDIUM FAB RESOURCE 1 7.0 SMALL FAB 1 & MEDIUM FAB RESOURCE 1 Comment: SMALL 1-Open rivet holes to 0.098" and C'sink as per dwg D3578



2-Assemble as per dwg D3578

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 PA

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:\_\_

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



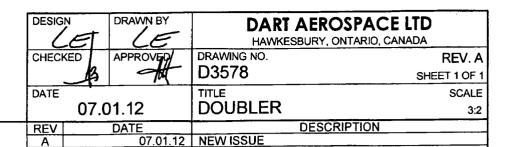
# **Dart Aerospace Ltd**

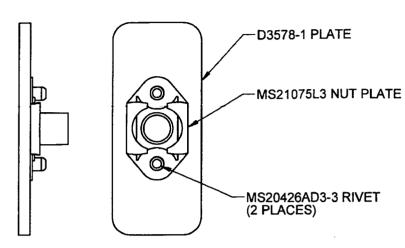
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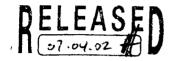
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NOTE: Date & initial all entries







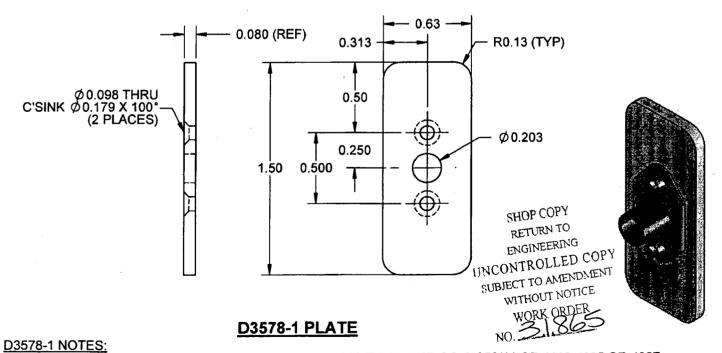


#### D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION		
Х	D3578-041	DOUBLER		
1	D3578-1	PLATE		
1	MS21075L3	NUT PLATE		
2	MS20426AD3-3	RIVET		

### **D3578-041 DOUBLER**

<u>D3578-041 NOTES:</u>
1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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